

Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM



Page 1

Item ID: D4323-23
Revision ID: PRELIM
Item Name: Access Panel, LH

Accept



Setup Start



Stop



Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

PRELIMINARY ISSUE

Run Start



Stop



Approvals: Process Plan: MF Date: 11-04-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Setup/ Run Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	--------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4323	<u>PAT PA8 BB</u>

100



HandThermo

Memo

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

0.00

105



HandThermo

Dry Material

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

0.00

0.00

Temp: 140 - 150°

Time IN: 6:00 PM 11/04/04

Time OUT: 7:00 AM 11/04/05

BB 11/04/05

BB 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM



Page 2

Item ID: D4323-23

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Access Panel, LH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA107 using tool DT9733

Dwg Rev:

Folio Rev:

PAS

A

11/04/05

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

11/04/05

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM



Page 3

Item ID: D4323-23

Accept



Setup Start



Revision ID: PRELIM

Item Name: Access Panel, LH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

DL
11/04/05

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

1

BB
11/04/05

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

-inspected to PA3
Dwg only

Suloulob (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM

Page 4

Item ID: D4323-23

Accept

Revision ID: PRELIM

Item Name: Access Panel, LH

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: Recall

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE SHAW'S AUTH MF

RELEASED _____ DATE _____

RD
2370SCRAPPED PER
DON CAMPBELL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:52:45 AM

Page 1

Work Order ID: 68008

Parent Item: D4323-23

Parent Item Name: Access Panel, LH



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: RIPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

787.2912

116576

3.46875 sq ft.

DL
4/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68008
Description: ADDRESS PANEL LH		Part Number:	4323-23
Inspection Dwg: 4323 Rev: PA8		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 11/04/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.00"	±0.030	18.1795	✓		TH 05	
10.58"	±0.030"	10.55	✓		TH 03	
9.78"	±0.030"	9.78	✓		TH-03.	

Measured by: JB

Date: 11/04/05

Audited by: 8 b Pat Day

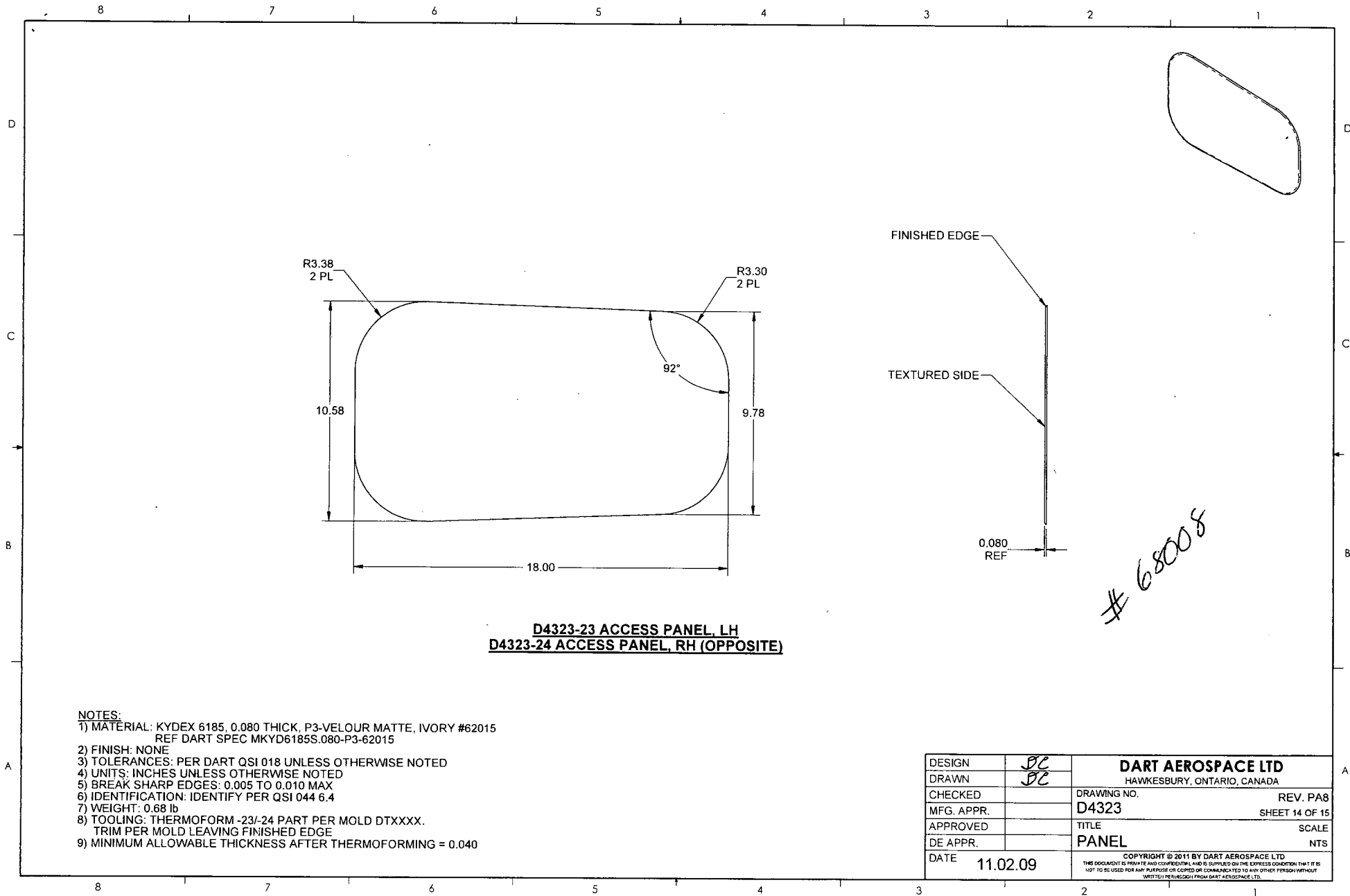
Date: 11/04/06

Preliminary Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4323-23 ACCESS PANEL, LH
D4323-24 ACCESS PANEL, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68 lb
- 8) TOOLING: THERMOFORM -23/-24 PART PER MOLD DTXXXX.
TRIM PER MOLD LEAVING FINISHED EDGE
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED		DRAWING NO.	REV. PA8
MFG. APPR.		D4323	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

The information contained in this transmission is privileged and confidential and intended only for the use of the individual or entity to whom it is addressed. If you are not the intended recipient, you are hereby notified that any distribution, copying, disclosure or taking of any action in reliance on the contents of this transmission is strictly prohibited and review by any individual other than the intended recipient shall not constitute waiver of privilege. If you have received this transmission in error, please notify me immediately and delete the original transmission.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

